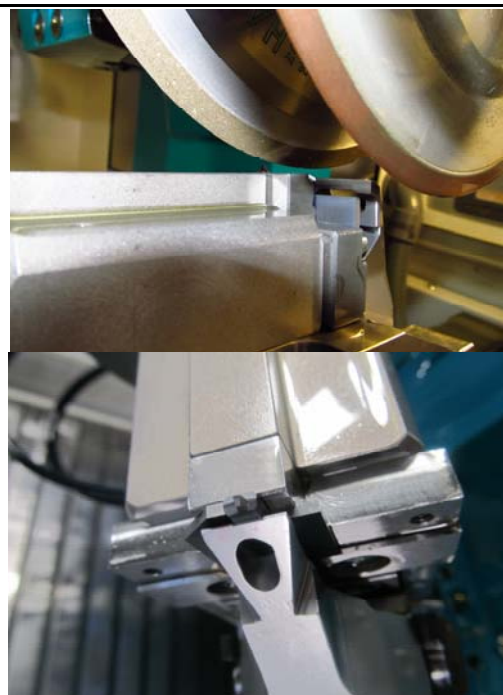
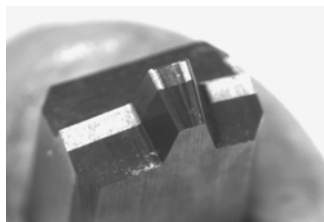












Threadinsert 8.35x4.5x3

A08-200

The batch of 10 pieces has been ground using 2 wheels only. This costs a lot of grinding time in plunge roughing. The time can be reduced by 1 to 2 minutes if the wheel used for plungeroughing has a torusradius of 1 mm. The fixturing was more suitable with a deeper pocket allowing better repeatability in sidepositioning of the insert.



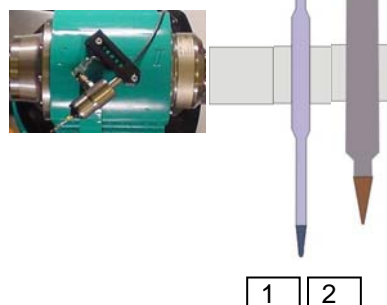
1. Cycletime for Production

Workpiece: 8.8x4.5x3 Material CARBIDE					
Operations					
	Prf RoughClr1	Prf Pgrd Clr2	Prf Pgrd clr1	Prf pol.clr2	Prf pol.clr1
Feed [mm/Min]	30	60	60	35	35
Power [kW]	2	1	1	1	1
Cutting speed [m/s]	22	22	22	22	22
Used wheels					
	1	1	1	2	2
Grinding time [s]	194	47	47	53	53
Total cycle time	6 Min 32				

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	14EE1 Ø200 D54R0.25
2	14EE1 Ø150 D46R0.08



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG

Control: Fanuc 310i

Accessories:

Responsible engineer: OP. 10.2.12

www.schneeberger.ch

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, UK, China

Coolant: Synthetic Oil, pressure 6 bar

Software: Quinto 5